

Work Order ID 71882

Wednesday, July 13, 2011 11:09:00 AM



Page 1

Item ID:	D2332-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Lid Prop Assembly 6.69" long				Stop	
Start Date:	7/14/2011	Start Qty:	8.00			
Required Date:	7/28/2011	Req'd Qty:	8.00			
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>11-07-13</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2332	Rev C1								

100		0.00							
Small Fab									
Small Fab									

Memo

1- Cut D2332-7 and D2332-5 to lenght as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

EP 11/08/22 (8)

110		0.00							
Brake NC									
Brake NC									

Memo

Punch and form D2332-11 to lenght as per dwg D2332 using DT8012
(need 2 per ass'y)

EP 11/08/23 (8)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Accept



Setup Start



Revision ID:

Stop



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Start Date: 7/14/2011 Start Qty: 8.00



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Required Date: 7/28/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

0.00



Small Fab

Memo

0.00

Small Fab

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

EP 11/08/23/24 (8)

130

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

Sub 1248
D2332-5
D2332-13
D2332-11
D2332-7
W/SS/24

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****

S.S Rod batch: *M114509*

11-8-23 (14)

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Reference:

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

PL 11-08-24

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11/08/24



170



Small Fab

Small Fab

Memo

1- Tumble

2- Assemble as per dwg D2332

0.00

0.00

11/08/24

8

→ 11/08/25



W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 ubg/2r

(X6)

Memo

0.00

190



Packaging

Packaging

Identify as per dwg & Stock Location: 512

0.00

11/8/25

(Signature)

Memo

0.00

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

11/8/25

Memo

0.00

11/8/25

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Picklist Print

Wednesday, July 13, 2011 11:08:57 AM

Page 1

Work Order ID: 71882

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long




Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.250  304 SS Round bar .250		Purchased	No			100	f	10.0427	0.1	0.842105			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT028		10.042736							
				114482		10.042736							
M304TR1.000W.049  304 RD Tube 1.00 x .049W		Purchased	No			100	f	28.1337	0.43	0.842105 3.621053			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT018		28.133684							
				111457		12.66							
				117598		15.473684							
M304TR0.500W.035  304 RD Tube .500 x .035W		Purchased	No			110	f	147.8796	1.25	10.52632			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT017		147.879638							
				115535		2.33							
				116720		1.66068							
				117598		143.888958							

Dart Aerospace Ltd

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Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 8.00

Required Qty: 8.00

AN4-4A Purchased No 170 Each 86.0000 1 8
Bolt

Location	Loc Qty	Loc Code
FP-B	40	
114615	40	
ST356	46	
114615	46	

AN960JD416L NAS1149D0416J Purchased No 170 Each 19.0000 3 24
Washer

LD M118131 (24X)

Location	Loc Qty	Loc Code
FP-B	17	
110153	17	
ST298	2	
110153	2	

MS21042L4 Purchased No 170 Each 4,206.000 1 8
Nut

Location	Loc Qty	Loc Code
ST300	4206	
117441	1959	
117601	747	
117885	1500	

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Shop Packet Print

Page 2

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

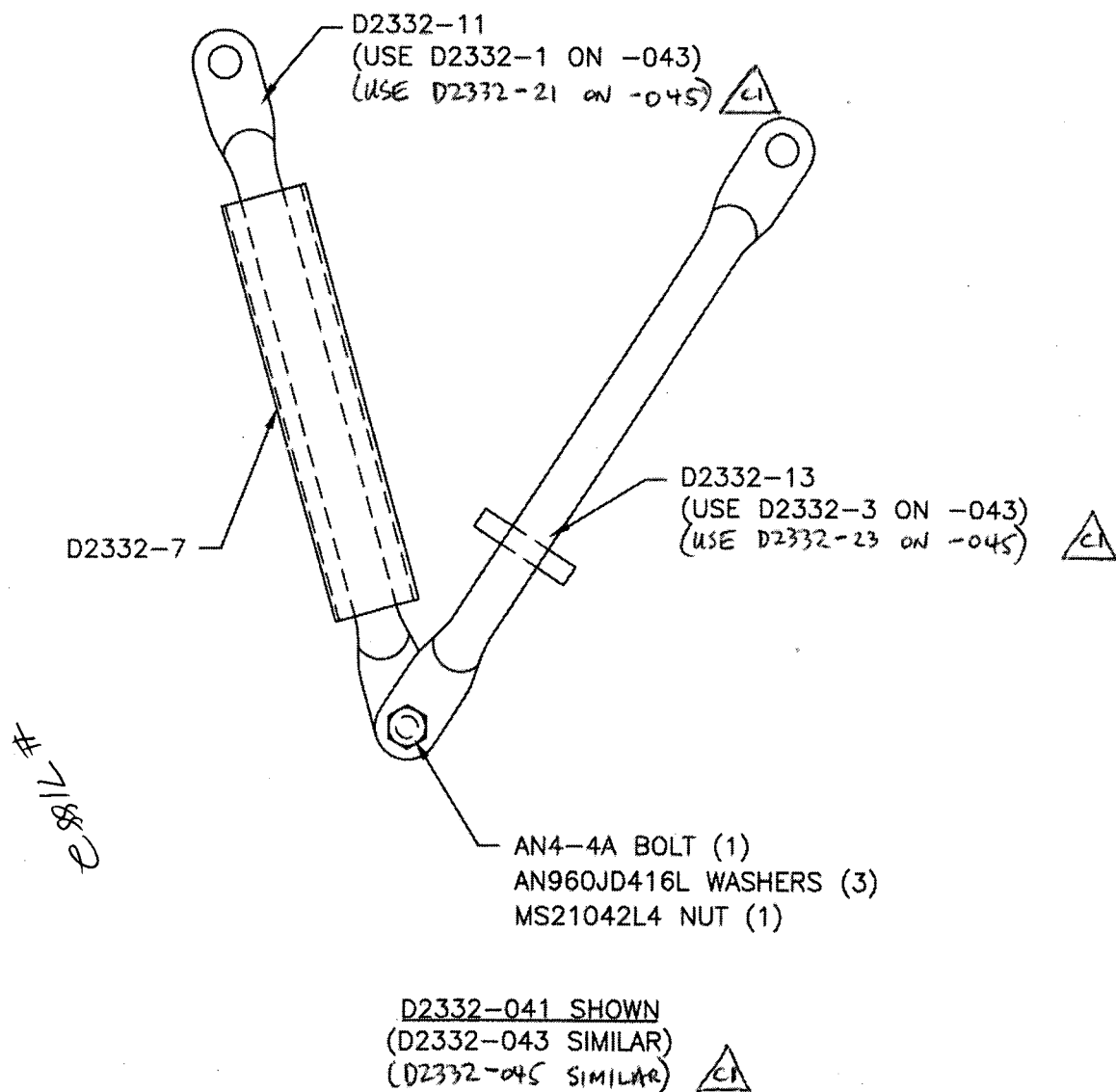
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	<i>[Signature]</i> 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04 *[Signature]*



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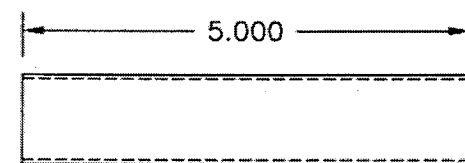
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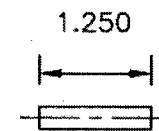


DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

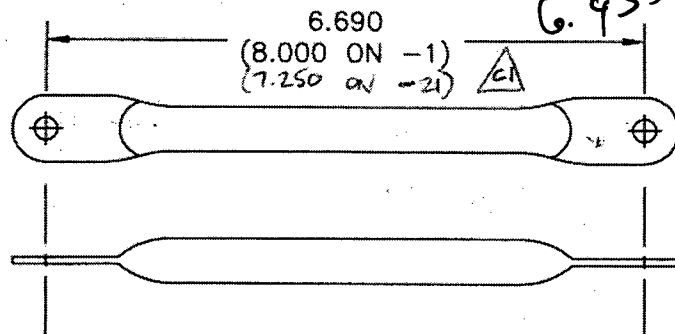
DESIGN	DRAWN BY	TITLE	REV. C
11	11	DART AEROSPACE LTD	
CHECKED 11	APPROVED 11	DRAWING NO. D2332	SHEET 2 OF 2
DATE 03.07.03		LID PROP ASSEMBLY	SCALE 1:2
C	03.07.03	MALE - 0.41 PROP 6.69" LONG (5.75)	
C1	03.08.06	MALE - 0.43 PROP 8.00" LONG (1.01)	
		ADD - 0.45 PROP (7.25" LONG)	



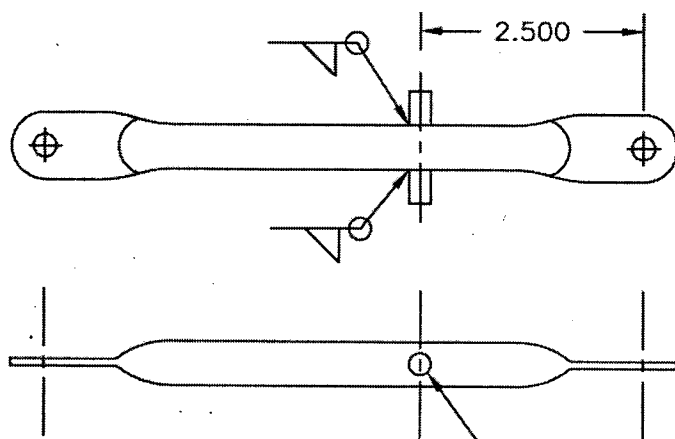
D2332-7 LOCKING COLLAR



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

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